

Work Order ID 112350

112350

Page 1

January-30-14 11:32:39 AM

Item ID: D429-793-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bearpaw
 Start Date: 1/30/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/30/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1/30/14 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
IIN-D429-793	C

MLJ 14-06-05

100	DOCUMENT CONTROL	0.00	DAS 06 9-89						
100									
DC	Memo	0.00							
Document Control	Photocopy bluefile and create labels per PPP D429-793-011 CHG 002								

JUN 06 2014

110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS 32 9-89 14/6/5 ① DAS 31 9-89

120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00	DAS 06 9-89						
Quality Control									

JUN 06 2014

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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 Revision ID: Stop *NS2*
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Packaging	0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D429-793-011								
	Location: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

JUN 06 2014

1 8 14-06-06

MLJ 14-06-06

MF 14-6-6

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Material									
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Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

January-30-14 11:32:39 AM

Page 1

Work Order ID: 112350
Parent Item: D429-793-011
Parent Item Name: Bearpaw

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: Rev. A New Issue 10/10/18 DL IPP Rev. B Change AN4C12A bots to AN4C13A bolts 10/11/05 DL IPP REV:C AS PER ECN 11-580 JLM 10-05-24 VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2274 Radius Block		Manufactured	No			110	Each	551.0000	12	12			DAS 32 9-89

108954/2
24109534

Location	Loc Qty	Loc Code
FG	12	
86855	12	
ST008	539	
109534	397	
110264	142	

DAS
06
9-89

DAS
31
9-89

D3456-1
Washer

Manufactured No Each 176.0000

8

DA
32
9-89

Location	Loc Qty	Loc Code
FG	7	
25701	7	
ST046	169	
103539	1	
103787	25	
107629	17	
109751	1	
111514	25	
111782	100	

DAS
06
9-89

DAS
31
9-89

D4176-1
429 Clamp, Top

Manufactured No Each 12.0000

111782
4 4

DAS
32
9-89

Location	Loc Qty	Loc Code
ST451	12	
63683	1	
87742	11	

63683 14
87742 34

DAS
31
9-89

DAS
06
9-89

DQA: _____ Date: _____



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Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 2

Work Order ID: 112350
Parent Item: D429-793-011
Parent Item Name: Bearpaw

Start Date: 1/30/14

Required Date: 1/30/14

Start Qty: 1.00

Required Qty: 1.00

D4212-1
429 Clamp Cushion

Manufactured No

Each 10.0000

Location

Loc Qty

Loc Code

ST451

10

81715

10

Manufactured No

Each 0.0000

D4353-041
Bearpaw Assembly

Manufactured No

Each 0.0000

D4354-041
Bearpaw Wearplate Assembly

Manufactured No

Each 5.0000

D4382-1
Angled Bearpaw Clamp

Location

Loc Qty

Loc Code

ST449

5

80403

5

Purchased No

Each 0.0000

AN4C11A
bolt

Purchased No

Each 40.0000

AN4C16A
BOLT

Location

Loc Qty

Loc Code

ST517a

40

122800

20

m126474

20

Purchased No

Each 49.0000

AN4C22A
BOLT

Location

Loc Qty

Loc Code

ST358

14

117423

14

ST517a

35

122800

20

122843

15

DAS 06 9-89
32 9-89
DAS 31 9-89

81715
112388
68-6 28 SVG
DAS 31 9-89

112259
DAS 32 9-89
DAS 31 9-89

DAS 31 9-89
80703 7x M 128634
8 7x M 128403
8 M 128177
DAS 31 9-89
DAS 32 9-89

DAS 31 9-89
DAS 32 9-89

DAS 32 9-89
4 m/b

DAS 31 9-89

m117423

January-30-14 11:32:39 AM

Shop Packet Print

Page 2

DQA: _____ Date: _____



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Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 112350
 Parent Item: D429-793-011
 Parent Item Name: Bearpaw

Start Date: 1/30/14 Required Date: 1/30/14
 Start Qty: 1.00 Required Qty: 1.00

MS21043-4
 Nut

Purchased No

Each 538.0000

20 128350 DAS 32 9-89

DAS 06 9-89

Location	Loc Qty	Loc Code
FG	40	
104603	40	
GA	41	
125807	41	
ST509	457	
m127255	457	

DAS 31 9-89

NAS1149D0463J
 WASHER

Purchased No

Each 6,573.0000

12 124778 DAS 32 9-89 DAS 31 9-89

DAS 06 9-89

Location	Loc Qty	Loc Code
ST294	2173	
M127693	2173	
ST510a	4400	
M127813	1400	
M127904	3000	

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DAS
06
9-09

JUN 06 2014

DART AEROSPACE LTD.

REFERENCE ONLY

IIN-D429-793
Page 5 of 6

5.0 PARTS LIST

QTY -011	Part Number	Description
X	D429-793-011	ULTRAPAW™ INSTALLATION
12	ID2274	RADIUS BLOCK
8	ID3456-1	WASHER
4	ID4176-1	CLAMP, TOP
6	ID4212-1	CLAMP CUSHION
2	D4353-041	ULTRAPAW™ ASSY
2	ID4354-041	WEARPLATE ASSY
2	ID4382-1	ANGLED CLAMP
8	AN4C14A	BOLT
8	AN4C16A	BOLT
4	AN4C22A	BOLT
20	MS21043-4	NUT
12	INAS1149D0463U	WASHERS

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Revision: C
Date: 11.04.08